

Work Order ID 75838

75838

Page 1

November-01-11 11:40:08 AM

Item ID: K10111 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Saddle, Skidtube 206
 Start Date: 01/11/2011 Start Qty: 5.00 *5* Cust Item ID:
 Required Date: 11/11/2011 Req'd Qty: 5.00 *5* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 11/11/01 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
K10111	B								
100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPP FOR D206-642-111 CHG002 FOR D206-642-113 CHG002	K10111 CHG002							
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

MLJ 11-11-2

11/11/2

11/11/09

XS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 75838

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Item ID: K10111 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Skidtube 206
 Start Date: 01/11/2011 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 11/11/2011 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP K10111								
	PPP D206-642-111								
	PPP D206-642-113 - P00								
	Location: <u> </u>								
	PPP rev: <u>ADPT</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

11/4/10

11/11/11
MF
11-11-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Work Order ID: 75838

75838

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 01/11/2011

Required Date: 11/11/2011

Start Qty: 5.00

Required Qty: 5.00

Comments:

IPP: F01.11.08 Revised Step 5 and Added Inspection Level

21SM

IPP REV:G

11.09.23 PER REV.B DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3-41A

Purchased

No

110

Each

1,975.000

8

40

**

AN3-41A

Bolt

Location

Loc Qty

Loc Code

ST354

16

118112

16

st510

1959

119042

1959

110

Each

5,788.000

12

60

**

AN4-6A

Purchased

No

AN4-6A

Bolt

Location

Loc Qty

Loc Code

ST356

788

116924

8

117514

6

118628

274

118838

300

119127

200

ST516

5000

119017

5000

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID: 75838

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Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 01/11/2011

Required Date: 11/11/2011

Start Qty: 5.00

Required Qty: 5.00

AN4C5A

Purchased

No

110

Each

529.0000

**

AN4C5A

BOLT

Location

Loc Qty

Loc Code

FP-B

54

112243

54

ST345

2

112243

2

ST355

473

112243

373

119017

100

Purchased

No

110

Each

2,841.000

**

AN5-7A

Bolt

Location

Loc Qty

Loc Code

ST337

15

117313

14

118422

1

ST516

2826

119017

2826

Purchased

No

110

Each

591.0000

**

AN6-44A

Bolt

Location

Loc Qty

Loc Code

ST343

7

119127

7

st510

584

119036

584

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 75838

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Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 01/11/2011

Required Date: 11/11/2011

Start Qty: 5.00

Required Qty: 5.00

D206-651-041

416201

Manufactured No

110

Each

41.0000

1 5

**

D206-651-041

206A/B GHW

Location

Loc Qty

Loc Code

FG

17

74002

17

FG125

24

74001

24

Manufactured No

110

Each

159.0000

16 80

**

D2652

D2652

Bushing

Location

Loc Qty

Loc Code

FG

44

31985

44

ST019

115

73833

115

Manufactured No

110

Each

48.0000

2 80 10

**

D2661-1

D2661-1

Saddle, LH Fwd Aft Out 206

Location

Loc Qty

Loc Code

ST435

30

73839

10

73841

10

74352

20

ST476

18

73840

8

November-01-11 11:40:12 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID: 75838

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Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 01/11/2011

Required Date: 11/11/2011

Start Qty: 5.00

Required Qty: 5.00

D2662-1

Manufactured No

110

Each

12.0000

D2662-1

Saddle, LH In 206

Location

Loc Qty

Loc Code

ST435

12

64557

6

73846

4

73849

2

Manufactured No

110

Each

951.0000

D2712

D2712

Set Screw

Location

Loc Qty

Loc Code

FG

50

29962

50

ST021

901

71160

1

73837

900

Manufactured No

110

Each

180.0000

D2884

D2884

Saddle Spacer

Location

Loc Qty

Loc Code

FG

10

29453

10

ST025

170

73823

170

**

**

**

2

10

2

10

50

10

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 75838

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Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 01/11/2011

Required Date: 11/11/2011

Start Qty: 5.00

Required Qty: 5.00

D2885

Manufactured

No

110

Each

206.0000

**

10

D2885

Saddle Spacer

Location

Loc Qty

Loc Code

FG

10

29199

10

ST025

196

73824

196

Manufactured

No

110

Each

46.0000

**

1

5

D3413-1

D3413-1

Ring

Location

Loc Qty

Loc Code

ST368

41

73821

41

ST420

2

66387

1

70773

1

ST467

1

73298

1

ST473

2

71041

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 75838

75838

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 01/11/2011

Required Date: 11/11/2011

Start Qty: 5.00

Required Qty: 5.00

MS21042L3

Purchased

No

110

Each

9,776.000

8

40

**

MS21042I 3

Nut

Location

Loc Qty

Loc Code

ST300

776

117441

16

117885

42

118451

90

118927

628

ST516

6000

119017

6000

ST518

3000

119075

3000

MS21042L4

Purchased

No

110

Each

13,239.00

12

60

**

MS21042I 4

Nut

Location

Loc Qty

Loc Code

ST300

2239

117441

51

117601

532

118451

656

118927

1000

ST516

6000

119017

6000

ST518

5000

119075

5000

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 75838

75838

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 01/11/2011

Required Date: 11/11/2011

Start Qty: 5.00

Required Qty: 5.00

MS21042L6

Purchased

No

110

Each

1,672.000

**

MS21042I 6

Nut

Location

Loc Qty

Loc Code

ST300

672

117677

25

118384

5

118927

48

118968

594

ST518

1000

119075

1000

NAS1149C0463R

Purchased

No

110

Each

1,422.000

**

NAS1149C0463R

Washer

Location

Loc Qty

Loc Code

FP-B

1

115358

1

ST297

1421

117735

421

119097

1000

NAS1149D0363J

Purchased

No

110

Each

2,570.000

**

NAS1149D0363J

Washer

Location

Loc Qty

Loc Code

ST019

16

117505

16

ST298

2554

117601

213

118077

51

118612

290

118968

2000

November-01-11 11:40:12 AM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 75838

75838

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 01/11/2011

Required Date: 11/11/2011

Start Qty: 5.00

Required Qty: 5.00

NAS1149D0463J

Purchased

No

110

Each

15,586.00

24

120

NAS1149D0463.I

Washer

**

4/11/13

Location

Loc Qty

Loc Code

ST019

25

118179

25

ST298

561

116025

16

116805

0

117291

1

117460

2

118179

35

118384

289

118612

1

119042

217

ST407

15000

119075

10000

119097

5000

NAS1149D0563J

Purchased

No

110

Each

3,803.000

8

40

NAS1149D0563.I

Washer

**

120
4/11/13

(5)

Location

Loc Qty

Loc Code

ST298

3803

118206

2803

118614

1000

40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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November-01-11 11:40:12 AM

Work Order ID: 75838

75838

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 01/11/2011

Required Date: 11/11/2011

Start Qty: 5.00

Required Qty: 5.00

NAS1149D0663J

Purchased

No

110

Each

3,180.000

4

20

NAS1149D0663.I

Washer

**

11/11/25/ (50)

Location

Loc Qty

Loc Code

ST298

180

115996

5

117977

1

118614

174

ST407

3000

119075

3000

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING SKIDTUBE AND SADDLE INSTALLATIONS:

AIRCRAFT	INSTALLATION
BELL 206 A/B	D206-642-111
BELL 206 A/B	D206-642-113

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE FOLLOWING TABLE (REF):

PART NUMBER	K10111	D206-642-111	D206-642-113
ID206-651-041	1	1	1
D2652	16	16	16
/D3413-1	1	1	1
/D2661-1	2	2	2
/D2662-1	2	2	2
D2712	10	10	10
D2884	2	2	2
D2885	2	2	2
/AN3-41A	8	8	8
/AN4C5A	1	1	1
/AN4-6A	12	12	12
AN5-7A	8	8	8
/AN6-44A	2	2	2
NAS1149D0363J	8	8	8
NAS1149D0463J	24	24	24
NAS1149D0563J	8	8	8
NAS1149D0663J	4	4	4
/MS21042-3 (OR L3)	8	8	8
/MS21042-4 (OR L4)	12	12	12
/MS21042-6 (OR L6)	2	2	2
/NAS1149C0463R	1	1	1

RELEASED
2011-09-23

B	ADD APPLICABILITY TO D206-642-113	AJS	11.09.19
A	NEW ISSUE	RF	00.05.17
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		K10111	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		SADDLE KIT	NTS
DATE	11.09.19	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-642 REV. O AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-642 REV. 4

REF FAA STC: SA00475SE

REF CANADIAN STC: SH98-4

REF EASA STC: EASA.IM.R.S.01320

PROCEDURE:

FOR D206-642-113/-114 SKIDTUBE INSTALLATION KITS, IT HAS BEEN DETERMINED THAT AN5-10A (FWD) AND AN5-11A (AFT) BOLTS ARE MORE APPROPRIATE BOLT LENGTHS FOR ATTACHING THE SKIDTUBES TO THE CROSSTUBES THAN THE AN5-7A BOLTS PREVIOUSLY PROVIDED IN THE KITS.

4.2 206A/B LOW GEAR SKIDTUBES (WITH RUN-ON LANDING WEARPLATES) 32.12 206A/B LOW GEAR SKIDTUBES (WITH RUN-ON LANDING WEARPLATES)

ITEM	QTY. -113	QTY. -114	PART NUMBER	DESCRIPTION
	X		D206-642-113	SKIDTUBE INSTALLATION, LH
		X	D206-642-114	SKIDTUBE INSTALLATION, RH

IS:

13	4	4	AN5-10A	BOLT
14	4	4	AN5-11A	BOLT

WAS:

13	4	4	AN5-7A	BOLT
14	4	4	AN5-7A	BOLT

FOR FURTHER DETAILS REFER TO PAGE 22, DETAIL A OF IIN-D206-642 REV. O, OR PAGE 30, DETAIL A OF ICA-D206-642 REV. 4.

A	NEW ISSUE	AJS	11.11.02
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE USA, INC KENT, WA	
DRAWN	AJS		
CHECKED	<i>GP</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9583	SHEET 1 OF 1
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>MP</i>	BOLT SUBSTITUTION	NTS
DATE	11.11.02	<small>COPYRIGHT © 2011 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	